

Work Order ID 109970

109970

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December-10-13 2:36:46 PM

Item ID: D4035-047

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lid Rib Assembly, Aft (Light)

Start Date: 12/10/13 Start Qty: 8.00

Required Date: 12/24/13 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 13-12-10 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4035	A
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100 Weld per dwg A/R Aluminum rod Batch: B123928 0.00

1000

Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-7 as per dwg D4035
- 2- Drill hole using DT9620 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

~~CC~~ 13-12-11 (6x)

110

QC10- Inspect visual per QSI004- ground welds 0.00

110

QC

Memo

0.00

Quality Control

6x D4035 14-02-11

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Page 2

Item ID: D4035-047 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Lid Rib Assembly, Aft (Light) Stop *NS2*

Start Date: 12/10/13 Start Qty: 8.00 *g* Cust Item ID:

Required Date: 12/24/13 Req'd Qty: 8.00 *g* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00				6x	DAS 43 2-89	14.02.11	
Quality Control									
130	Identify as per dwg & Stock Location: <u>WIA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(6x) CC 14.2.11

MLS 14.02.11

14.02.11

December-10-13 2:36:49 PM

109970

D4035-047

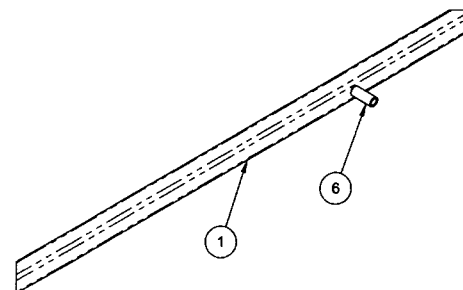
Start Date: 12/10/13**Required Date:** 12/24/13**Start Qty: 8.00**

Required Qty: 8.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC
per dwg revA 10.03.15 verified by:EC
PER DWG REV.pb2 DD VRF:JFS

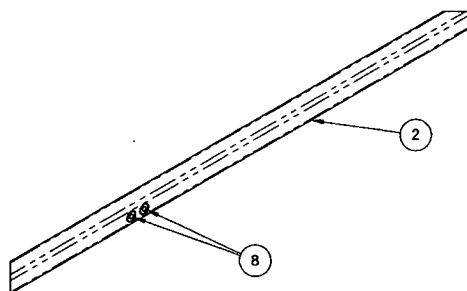
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4035-11		Manufactured	No			100	Each	8.0000	2	16			
D4035-11													
Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		8							
				105615		8							
M6061T6TS0.750W.06		Purchased	No			100	f	175.9653	1.875	16			
2													
M6061T6TS0 750W 062													
6061-T6 SQ Tube .75 x .75 x .062W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		175.96533							
				122200		11.7548							
				124595		164.21053							

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

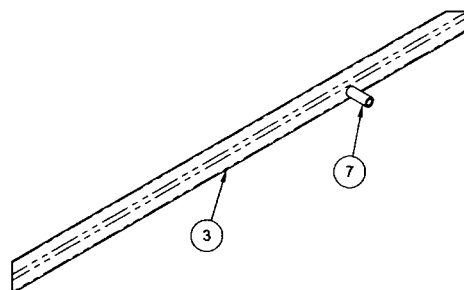


D4035-041 BASKET LID RIB ASSY, FWD

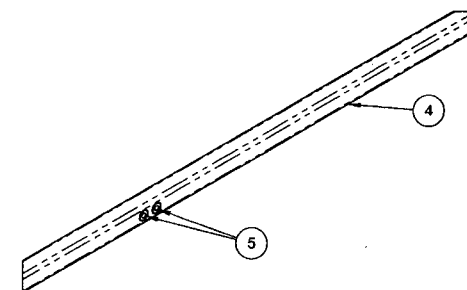
109970
ML5
13-12-10



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

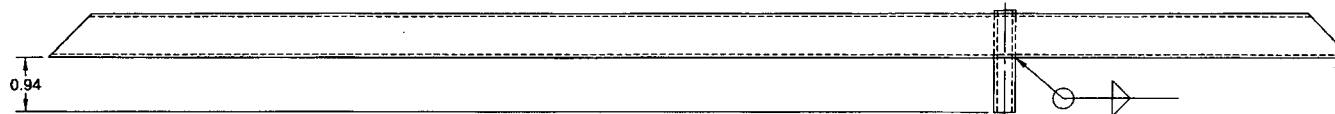
RELEASED
2010-03-12
AM

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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D

D



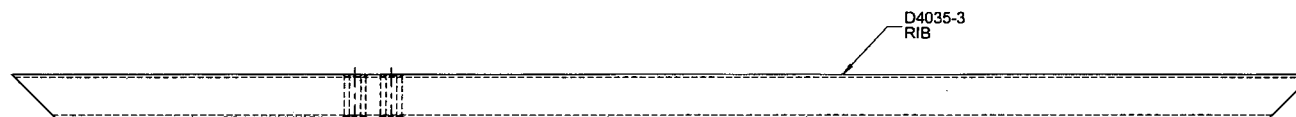
D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD

C

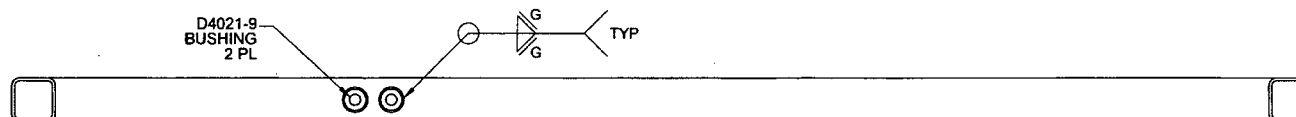
C



D4035-3
RIB

B

B



D4021-9
BUSHING
2 PL

TYP

D4035-043 BASKET LID RIB ASSY, AFT

RELEASED
2010-03-12
AWP

A

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

D4035-11
BUSHING
2 PL

G
G
TYP

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

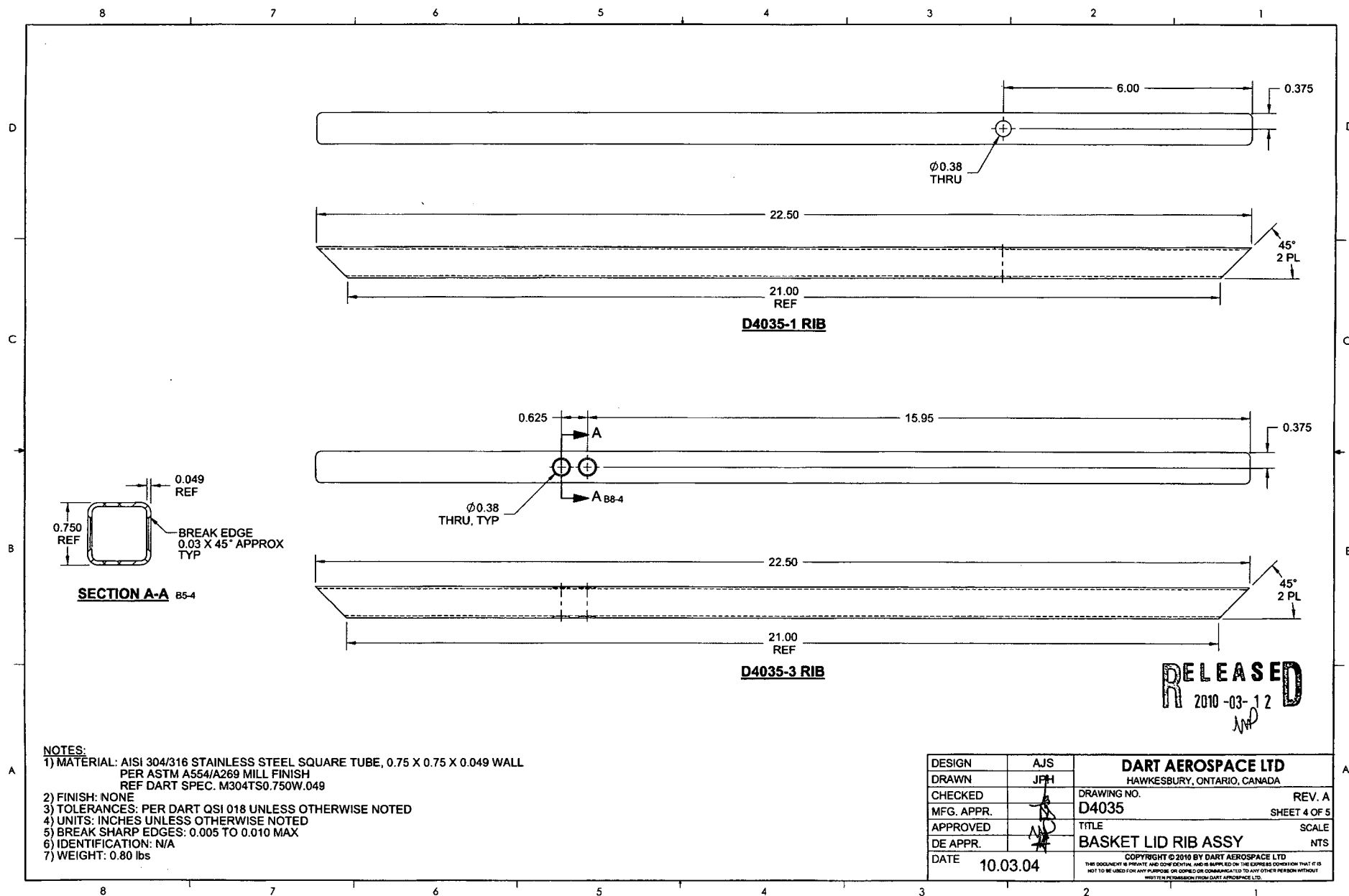
RELEASED
R 2010-03-12
AW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4035	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID RIB ASSY	NTS
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